



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-145
Job Sheet 168919



Part No: D205-634-145

Job Qty: 1 ea

Part Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/24/17

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Sequoia Helicopters Ltd (CSEQU01)

30750 Threshold Drive Abbotsford, BC, V2T 6H5 Canada ph:(604) 852-1704

Note: DWG D2580-049 REV H, IIN-D205-634 REV1 IPP REV:B 14.04.21 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Skidtubes		
110	Skidtubes	1 pcs	1/11/18	1/11/18	0.00	2.01	Skidtubes		MAG
120	CNC Bend Skidtubes	1 pcs	1/11/18	1/11/18	0.49	0.60	CNC Bend Skidtube		MAG
130	Skidtubes	1 pcs	1/11/18	1/11/18	0.00	2.01	Skidtubes		MAG
140	QC	1 pcs	1/11/18	1/11/18	0.00	0.00	QC5		BE
150	Skidtubes	1 pcs	1/11/18	1/11/18	0.00	2.01	Skidtubes		MAG BE
160	QC	1 pcs	1/11/18	1/11/18	0.00	0.00	QC10		38 DAS
170	QC	1 pcs	1/11/18	1/11/18	0.00	0.00	QC5		9-88 38
180	HandFinish	1 pcs	1/11/18	1/11/18	0.00	1.07	HandFinish2		2018/02/06 BE
190	Powdercoat	1 pcs	1/11/18	1/11/18	0.00	0.18	Powdercoat1		BE 18-02-08
200	QC	1 pcs	1/11/18	1/11/18	0.00	0.00	QC3		BE 18-02-08
210	HandFinish	1 pcs	1/12/18	1/12/18	0.00	1.07	HandFinish4		BE 18-02-08
220	QC	1 pcs	1/12/18	1/12/18	0.00	0.00	QC5		BE
225	DC	1 pcs	1/12/18	1/12/18	0.00	0.00	DC		
230	Packaging	1 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3		DAS
240	QC21-FG	1 Ea	1/12/18	1/12/18	0.00	0.00	QC21		21 9-88

Part Op 110 - 1- PICK D2580-1

Descriptions: 120 - 1-Bend as per program D2580.C on CNC Bender and Folio FT 16

130 - 1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required.

180 - And realodine tube as per QSI 005

210 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

220 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

225 - Photocopy D205-634 bluefile & type labels per PPP D205-634-145 CHG001

230 - Identify and pack for shipping as per PPPD205-634-145 Location : FG073

AIR BE
M138673

M138467. START: 1:20

ODT: 520° FINISH: 1:50.

Wing walk M138711

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2580-1 5014926	1	12	0	0
210-HandFinish	AN3-5A 5013737	2	216	0	0
	AN4-45A 5038734	8	31	0	0
	D2570 5030004	16	196	0	0

000663

DART
AEROSPACE
S038206

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Replacement Skidtube with Thru - Bolt Standard Wearplates
Fits LH or RH

PART NO: D205 - 634 - 145

Original Serial #: S038206

Revision:

Operation:

Change No:

Start up Operation
CHG001

02/01/18
Job No: 168919

1st CAP DTB215

(Ref: 5.338, 5.985,
10.832, 3.63

#3 Run on Wearplate + .508"

D2576-3 F151399 1
 D2594-1 5025442 8
 3x F159710 D2594-3 503583615 8
 D2855 F151613 1
 D4202-1 5030798 24
 D5061-1 5019473 1
 D5061-3 F165527 1
 504- MS21042-4 5038763 8
 NAS1149D0332J 5020606 2

66	0	0
265	0	0
282	0	0
84	0	0
179	0	0
1	0	0
1	0	0
3	0	0
1,792	0	0

Part Specifications

Specifications could not be found.

Plex 11/24/17 3:24 PM dart.poulin.mario

4.7 51 11/30

ITEM	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X	-041	-047	-048	D2880-041	SKIDTUBE ASSEMBLY
2					D2880-046	SKIDTUBE ASSEMBLY
3			X		D2880-047	SKIDTUBE ASSEMBLY
4				X	D2880-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2880-1-180	EXTRUSION
21			18	18	D2870	BUSHING
22	1	1	1	1	D2878-3	STEP
23			4		D2879	SPACER
24	16	16	8	8	D2884-1	PLUG
25	16	16	8	8	D2884-3	O-RING
26	1	1	1	1	D2886	205 WEB
27	1	1	1	1	D2885	AFT CAP
28	1	1			D3584-8	WEARSHOE
29	1	1			D3584-9	WEARSHOE
30	1	1			D3584-11	WEARSHOE
31	1	1			D3584-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1	1	D4406-041	WEARPLATE ASSEMBLY
34			1	1	D4406-043	WEARPLATE ASSEMBLY
35				1	D6081-1	FINO WEARPLATE
36				1	D6081-3	AFT WEARPLATE
60	50	50			AL57-1032-130 or AK57-1032-130 or AK54-1032-130 or AELS-1032-130	INSERT
51	50	50			AN5CA	BOLT
52	2	2	2	2	AN5-5A	BOLT
53			8	8	AN4-4SA	BOLT
54	50	50			NAS1148D0332R	WASHER (AN880C10L)
55	2	2	2	2	NAS1148D0332J	WASHER (AN86UD10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2880 WEB POWDER COAT (-041/-047/-048) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 POWDER COAT (-046) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK SHARP EDGES: 0.003 TO 0.010 MAX.
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D2880-041 = 53.7 lbs
D2880-046 = 53.1 lbs
D2880-047 = 45.1 lbs
D2880-048 = 52.0 lbs
- 9) WELDING PER DART QSI 004.
- 10) INSERT D2880 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 11) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 12) USE DART DRILL TEMPLATE DT8217 & DT8637 ONLY FOR D2880-041/-045 TO LOCATE AND DRILL 20-287 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (60 PLACES) AFTER FINISH. INSTALL AN5CA BOLTS AND NAS1148D0332R WASHERS WITH SIKAFLEX-241-291.
- 13) INSERT D2884-1 PLUG CW D2884-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2880-041/-045 AND 8 PLACES FOR D2880-047/-048)
- 14) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2885 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

REV.	DESCRIPTION	BY	DATE
H	SHEET: P. DELETE D3688-1/5-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS.	SAD	17.06.09
G	ADDED -048, -047 WEIGHT UPDATED PER DSI 8888	AJS	14.04.09
F	INCORPORATE DED D2880-E-1 PER PART12-218	DC	13.06.20
E	ADD D2880-047 (ZN CA-7) AND D2880-7 (ZN BS-9); INCLUDED DED D2880-Q-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8637 WAS TD2377-205 (ZN CA-1)	RF	11.06.21
D	CHANGE TO 55 WEARPLATES AND GASKETS, INCLUDE DED 8124/8183	PH	07.04.06
C	REDRAWN, INCLUDED DED 9094/ 9097	CP	06.06.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
DESIGN	DS		
DRAWN	SAD		
CHECKED	<i>[Signature]</i>		
INFO. APPR.	D2880		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	17.06.09		

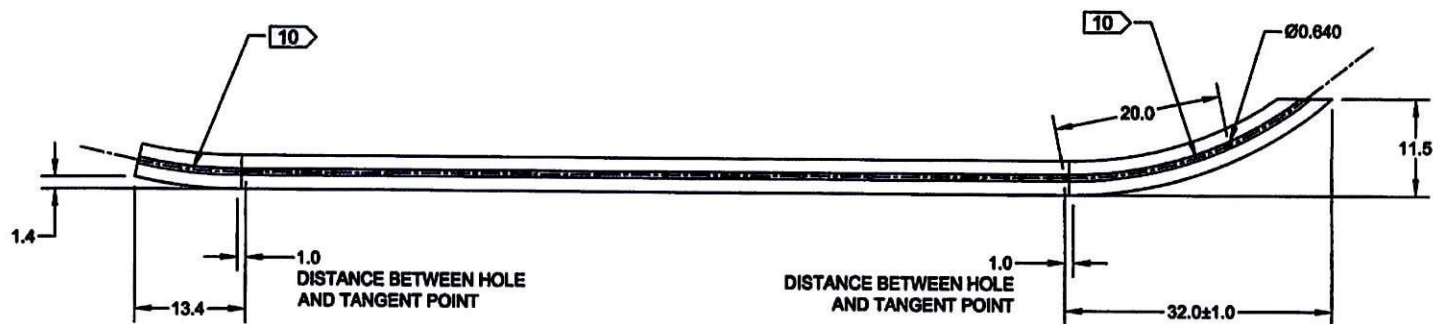
RELEASED
2017 JUL 05
BOM-T-304

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	D2880
REV. H	SHEET 1 OF 9
TITLE	205 SKIDTUBE ASSEMBLY
SCALE	NTS
DATE	17.06.09

COPYRIGHT © 1998 BY DART AEROSPACE LTD
This document is the property of DART AEROSPACE LTD and is not to be used for any other purpose without the written permission of DART AEROSPACE LTD.

2017 JUL 05 *af*

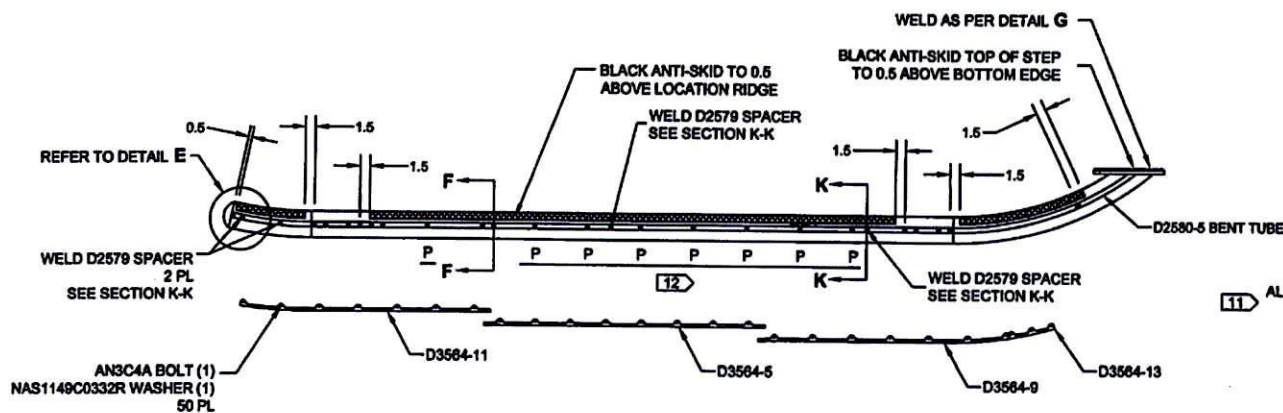
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. H SHEET 2 OF 2
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580	
MFG. APPR.	<i>[Signature]</i>	TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE 17.06.09		COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR ANY PURPOSES OR ON ANY EQUIPMENT WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

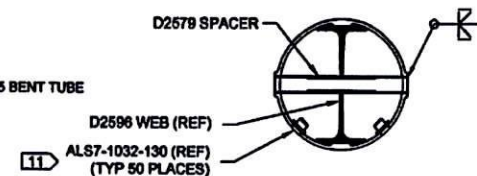
RELEASED
2017 JUL 05 4P

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 3 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMERCIALITY TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



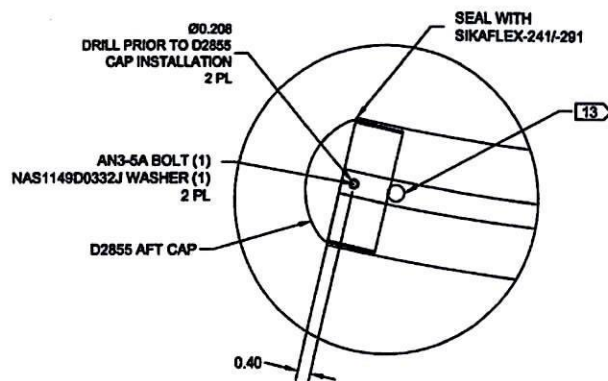
D2580-045 ASSEMBLY DETAIL

**SECTION K-K
SCALE 5X**

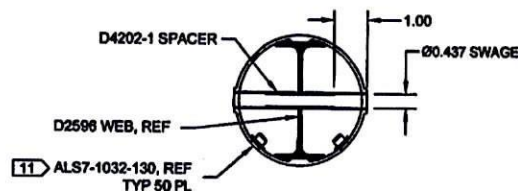


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

**DETAIL E
SCALE 5X**

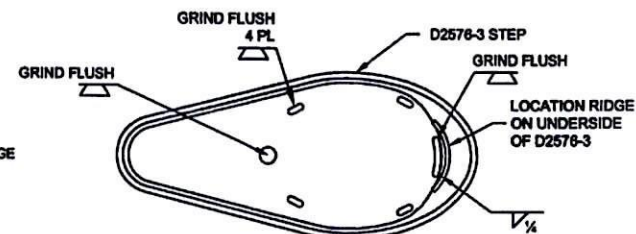


**SECTION F-F
SCALE 5X**



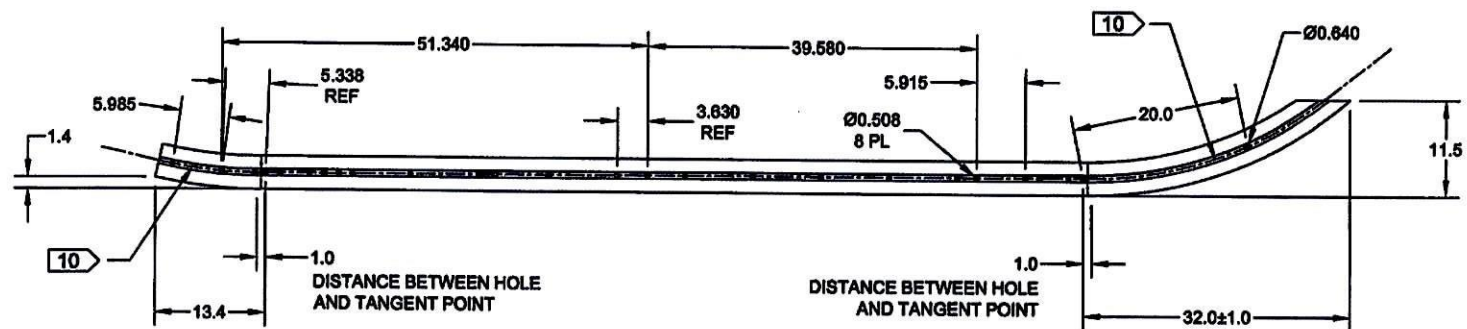
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G
SCALE 5X**



RELEASED
2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 4 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

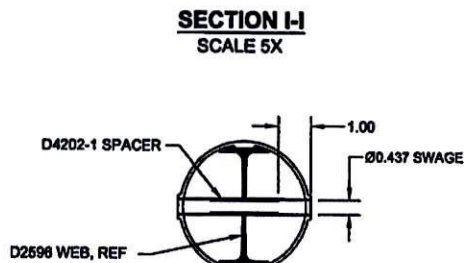
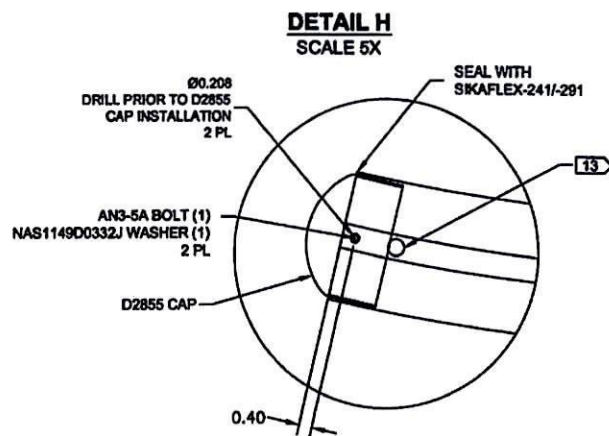
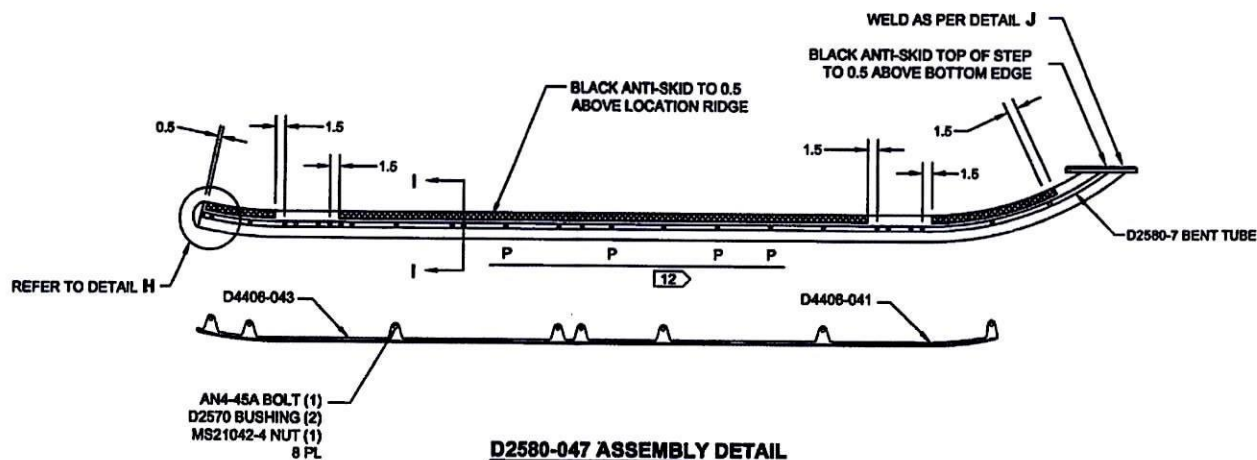


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

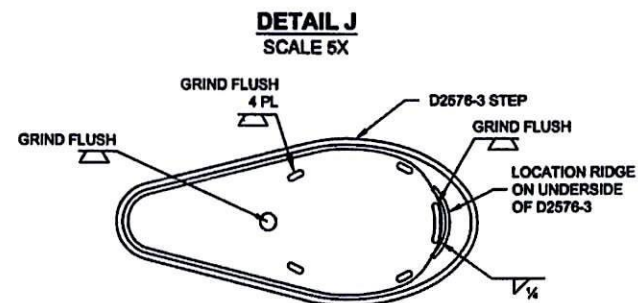
RELEASED

2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580	REV. H SHEET 5 OF 9
MFG. APPR.	<i>[Signature]</i>	TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	17.06.09		



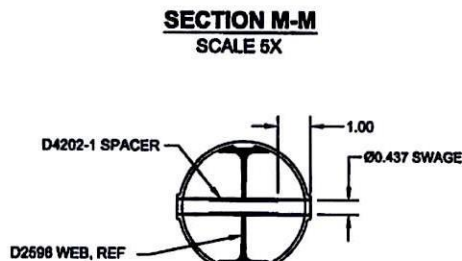
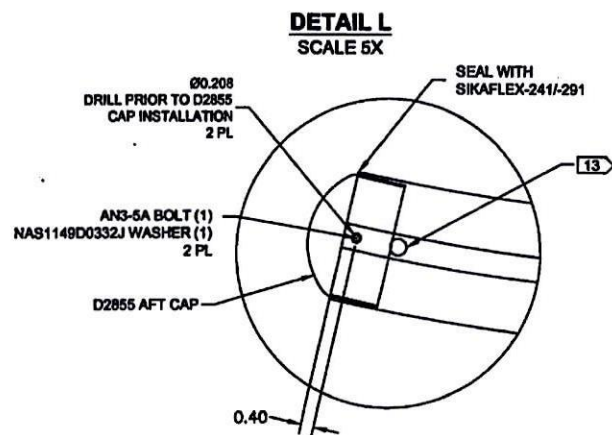
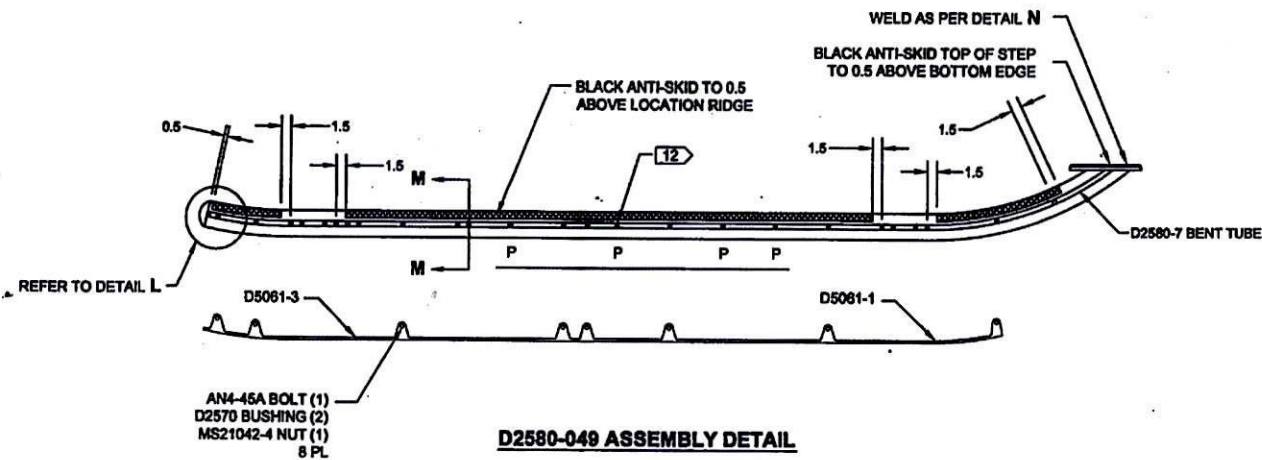
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



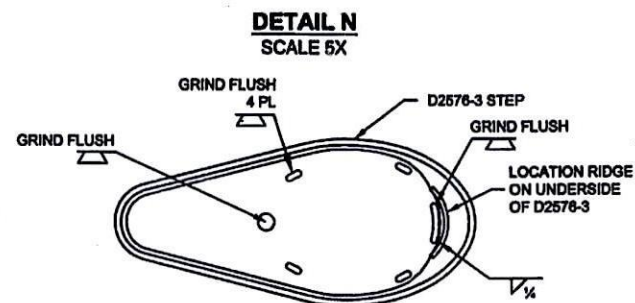
RELEASED

2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580	REV. H SHEET 6 OF 9
MFG. APPR.	<i>[Signature]</i>	TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	17.06.09		



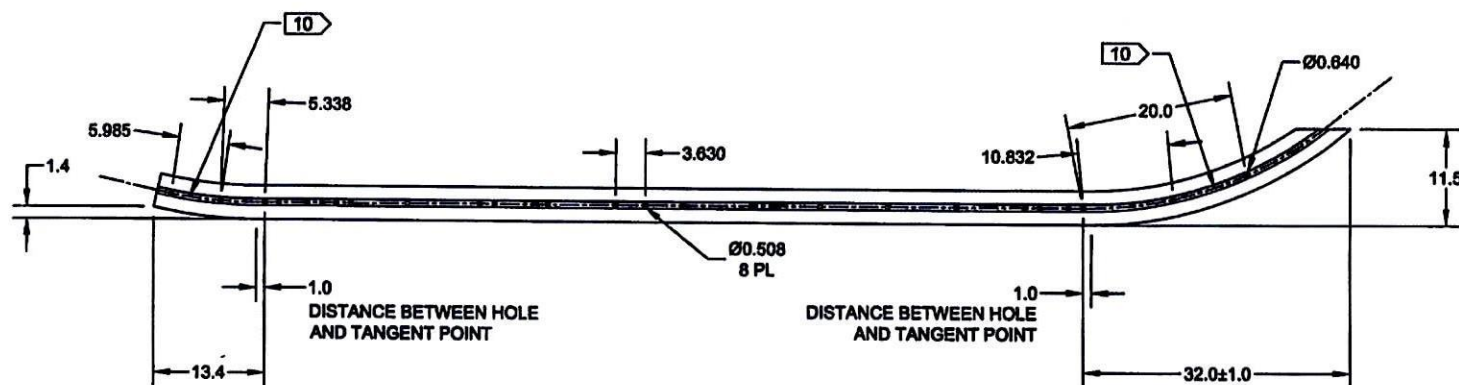
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



RELEASED

2017 JUL 05

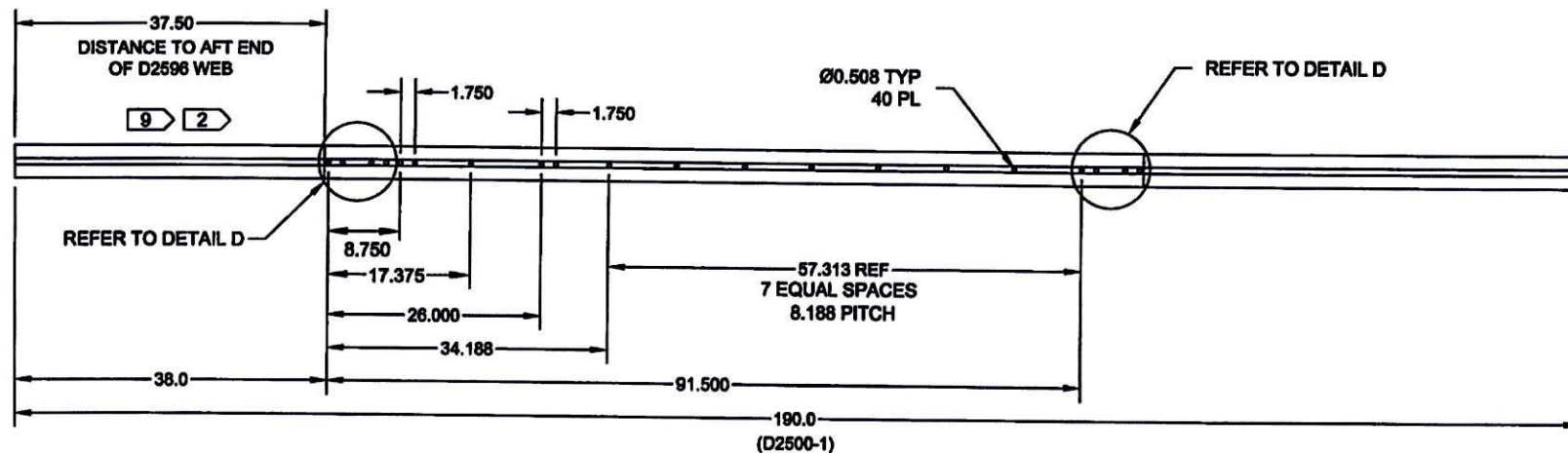
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 7 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OFFICE OR COMMUNITED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



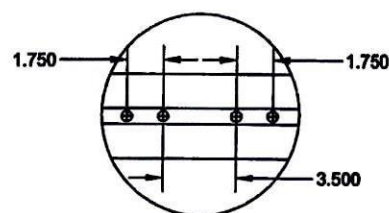
RELEASED

2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 8 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D2580-101 TUBE



DETAIL D
SCALE 5X

RELEASED
2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 9 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRESENTED AND COMPROMISED, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR IN ANY MANNER OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1